

Work Order ID 53335-1

October 30, 2009 1:11:14 PM

Page 1

Item ID: PB67-43001-31
 Revision ID: ~~BT C~~ PRELIM 09.12.21
 Item Name: PB67-43001-31 Upper Restraint Weldment
 Start Date: 11/2/2009 Start Qty: 6.00
 Required Date: 11/23/2009 Req'd Qty: 6.00
 Reference:

Accept

Cust Item ID:
 Customer:

PRELIMINARY ISSUE

Approvals: Process Plan: MF Date: 09-10-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
 Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	REV B1 REV. C 09.12.21

100
 FLOW WATER JET

Waterjet
 FLOW CNC Waterjet

6061
 .040

110
 QC2- Inspect parts off machine FAI/FAIB

QC
 Quality Control

Memo

0.00

QC8- Inspect parts - second check

QC
 Quality Control

Memo

0.00

0.00
 0.00 B1 B1
 1-Cut as per Dwg B67-43001-321 ☐ Dwg Rev: B1 ☐ Prog Rev: B1

***grain direction along 25.00" ***2-Deburr if necessary
 24.85 09.12.21

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

09-12-17
 09-12-17

09-12-17
 09-12-17

09-12-17
 09-12-17

09-12-17
 09-12-17

09-12-17
 09-12-17

09-12-17
 09-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53335

October 30, 2009 1:11:14 PM



Page 2

Item ID: PB67-43001-31

Accept



Setup Start



Revision ID: B1

Item Name: PB67-43001-31 Upper Restraint Weldment

Stop



Start Date: 11/2/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg B67-43001

0.00

0.00

Rev. c Prelim

SB 09/21/22

7

8

9

Pho ->

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/02/22

10

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

SB 10/02/22

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-31 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>53335</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/16	130	1 part crack at the bend ROOT CAUSE: MFG DID NOT CONSULT ENG. PRIOR TO RELEASE W/O.	09.12.16	Scrap + destroy NO replace PER REV. C PRELIM.	SB 09/12/16	SB 09/12/16	09.12.16	09.12.16
09.12.21	130	FLAT PATTERN TOO LOW: 25.00 SHOULD BE 24.65. SCRAP QTY 1! MODIFY	09.12.21	Scrap + destroy No replace	SB 09/12/21	SB 10/01/25	09.12.21	10/01/25
		OTHER PARTS AS FOLLOWS: REDUCE FLAT PATTERN HEIGHT BY 0.165" AT BOTH ENDS OF PLATE. THEN BRAKE/BEND.						

NOTE: Date & initial all entries

Work Order ID 53335

October 30, 2009 1:11:14 PM



Page 3

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Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

Memo

0.00

START TIME:

1:45pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2nd 10/02/24

(27) 0

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

br 10-02-24

(7)

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- Assemble as per dwg B67-43001

R 10-10-13 5

0

W/O:		WORK ORDER CHANGES					
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October 30, 2009 1:11:14 PM



Page 4

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

8/10/13 (X5) 0.00

Quality Control

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

POSITIVE RECALL

EFFECTIVE 10-10-14 AUTH LL

RELEASED DATE 10-10-14

close Mel is. will. pull on up of PB67-43001-31 to complete

10/10/14 JF
MK 10-9-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October 30, 2009 1:11:13 PM

Page 1

Work Order ID: 53335

Parent Item: PB67-43001-31RevB1

Parent Item Name: PB67-43001-31 Upper Restraint Weldment

Start Date: 11/2/2009

Required Date: 11/23/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.090

Purchased

No

180

sf

114.8403

2.7411

5.5
3.66

11/9-12-17
11/9-12-9

8



6061-T6 .090 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.8403

108595

1.41

109184

16.3403

111382

96

19295

1.09

109184
11382

MS27039-1-09

Purchased

No

100

Each

765.0000

30.0000

10.10.13



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

765

107378

23

111650

500

18057

209

8912

33

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 30, 2009 1:11:13 PM

Page 2

Work Order ID: 53335



Parent Item: PB67-43001-31RevB1



Parent Item Name: PB67-43001-31 Upper Restraint Weldment

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Required Date: 11/23/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149F0316P

Purchased

No

180

Each

96.0000

30.0000



WASHER

10.10.13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

96

111117

9

111124

5

112940

82

25

PB67-43001-33RevB1

Manufactured

No

180

Each

6.0000

6.0000



Upper Pad Assembly

10.10.13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

40294

1

41505

5

5

October 30, 2009 1:11:13 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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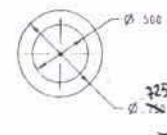
NOTE: Date & initial all entries

RELEASED
4-01-20

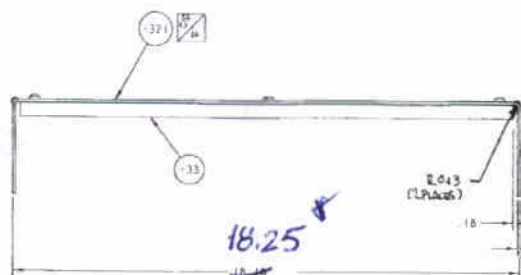
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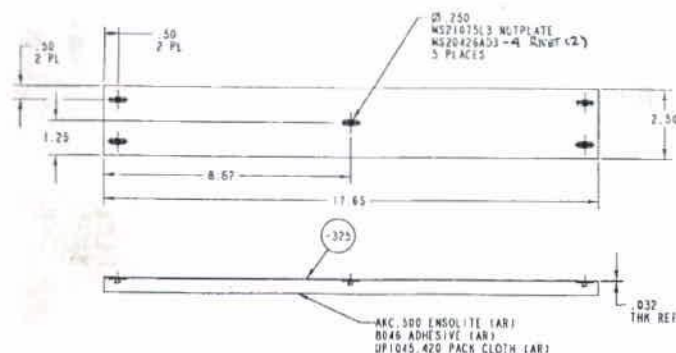
Ø 1.93 THRU
MATCH DRILL WITH
EXISTING OUTPLATE
LOC'S OF -33
MS21029-1 Ø9 SCREW
NAS1148 Ø316P WASHER
5 PLACES



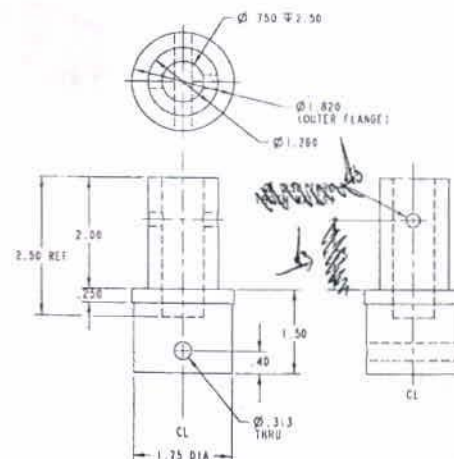
④ -299 BUSHING
SCALE 2.000
MAT: 304 CRES. COND A



① -31 UPPER RESTRAINT WELDMENT
SCALE 0.500



① -33 UPPER PAD ASSY
SCALE 0.500
MAT: FOR -325: .032 THK 7024 T3 AL.
QQ-A-250/4



① -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
QQ-A-200/3

PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75050
FILED: 10/24/2013
D105UV8 B57-43001
SCALE: 1:1
DATE: 10/24/2013

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

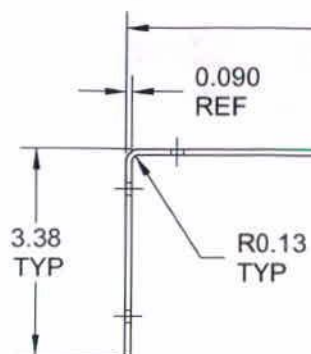
NOTE: Date & initial all entries

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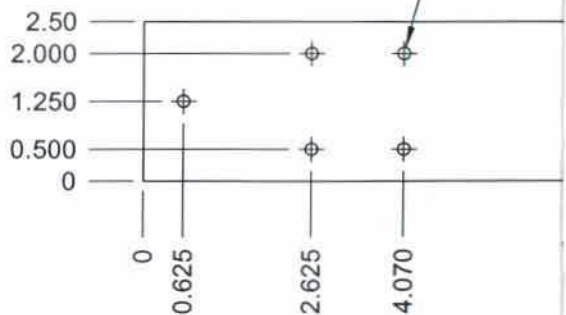
7

2

1



Ø0.194
TYP



**PRELIMINARY
ISSUE** 09.12.21

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SH
PER AMS-QQ-A-250/11 OR AMS 4025/4
REF. DART SPEC. M6061T6S.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART
POWDER COAT GREEN SANDTEX (4.3.5.)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.53 lbs

PREMIER AVIATION DRAWING IAW DART QSI
043. FOR PREVIOUS REVISIONS, REFER TO
END 43 OF PREMIER AVIATION DRAWING
01. REASON: SEE PAR#09-011.

MB

09.03.12

DESCRIPTION

BY

DATE

RW

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

REV. C

B67-43001-321

SHEET 1 OF 1

TITLE

SCALE

N/A

UPPER RESTRAINT PLATE

NTS

2

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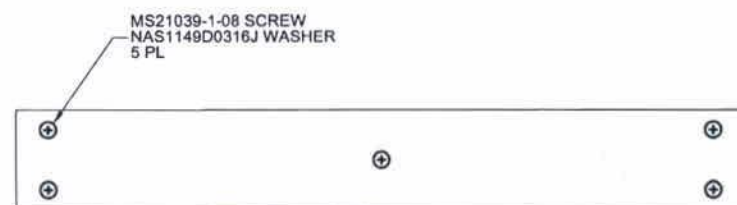
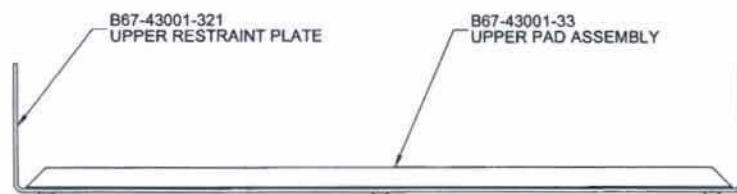
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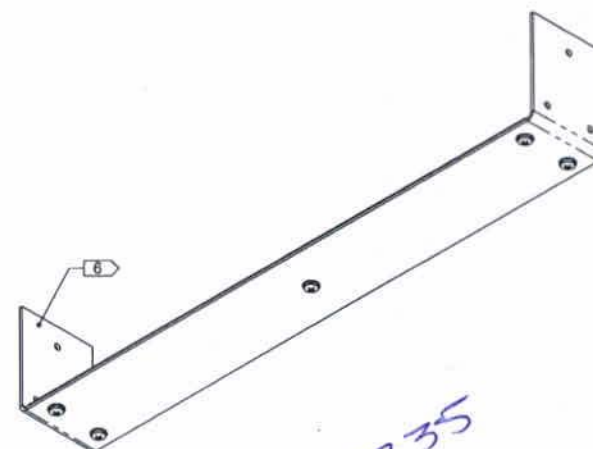
2

1

ITEM	QTY -31	P/N	DESCRIPTION
1	X	B67-43001-31	UPPER RESTRAINT ASSEMBLY
3	1	B67-43001-33	UPPER PAD ASSEMBLY
4	1	B67-43001-321	UPPER RESTRAINT PLATE
6	5	MS27039-1-08	SCREW
7	5	NAS1149D0316J	WASHER



B67-43001-31 UPPER RESTRAINT ASSEMBLY



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-31" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.76 lbs

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 041. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-31	SHEET 1 OF 1	
APPROVED	AS	TITLE	SCALE	
DE APPR.	N/A	UPPER RESTRAINT ASSEMBLY	NTS	
DATE	09.06.19		<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	